

Dart Aerospace Ltd.
1270 Aberdeen St
ON

D119-646-241

Job Sheet 198190



Part

Job Qty: 1 pcs

with Heavy Duty Wearplates - Fits LH or RH

Part Weight: 0 lbs

Job Created: 7/23/19

Due Date: 12/2/19

Type: SOLD

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG IIN-D119-646 REV D, D3887-045 REV E SHEETS 4, 6-11 IPP RevA: New issue DD verified by:EC IPP
REVB 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD
verf:JLM IPP REV:D 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Skidtubes - 1	1 pcs	12/2/19		0.00	0.05	Skidtubes - 1			00
							Skidtubes - 2			
							Skidtubes - 3			
							Skidtubes - 4			
							Skidtubes - 5			
							Skidtubes - 6			
							Skidtubes - 7			
120	Handfinish - 1-1 Chemical-B4B	1 pcs	12/2/19		0.00	0.79	Handfinish - 1 - 1 - B4B			
							Handfinish - 1 - 2 - B4B			
							Handfinish - 1 - 3 - B4B			
							Handfinish - 1 - 4 - B4B			
							Handfinish - 1 - 5 - B4B			
							Handfinish - 1 - 6 - B4B			
							Handfinish - 1 - 7 - B4B			
							Handfinish - 1 - 8 - B4B			
							Handfinish - 1 - 9 - B4B			
							Handfinish - 1 - 10 - B4B			
							Handfinish - 1 - 11 - B4B			
							Handfinish - 1 - 12 - B4B			
							Handfinish - 1 - 13 - B4B			
							Handfinish - 1 - 14 - B4B			
							Handfinish - 1 - 15 - B4B			
							Handfinish - 1 - 16 - B4B			
							Handfinish - 1 - 17 -			

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 819 832-6200
Email: sales@dartaero.com
www.dartaero.com

Container No: S201854

Part: D119-646-241

Job No: 198190

Serial No/Batch: S201854

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, STC LoA P.

				B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
121 QC 7	1 pcs	12/2/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
125 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	

130 Skidtubes - 2 - B4B	1 pcs	12/2/19	0.00 2.38	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
135 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	AE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Skidtubes - 3 - B4B	1 pcs	12/2/19	0.00 2.38	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Skidtubes - 4 - B4B	1 pcs	12/2/19	0.00 2.44	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	

170 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				180 QC 10	1 pcs
QC 10 - 18					
QC 10 - 24					
QC 10 - 43					
QC 10 - 50					
QC 10 - 58					
QC 10 - 9					
190 Handfinish - 2-1 Pressure- B4B	1 pcs	12/2/19	0.00 0.33	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	12/2/19	0.00 0.20	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
210 QC 3	1 pcs	12/2/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
QC 3 - 24					
QC 3 - 61					
QC 3 - 81					
240 Handfinish - 4-1-Assembly- B4B	1 pcs	12/2/19	0.00 0.79	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 -	

Plex 7/23/19 1:43 PM Dart.lajeunesse.marie

						B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
250 QC 5	1 pcs	12/2/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
260 Packaging 3-1 - Stock - B4B	1 pcs	12/2/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	

					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
265 DC - 1 - B4B	1	12/2/19	0.00	0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
270 QC 21 - FG	1	12/2/19	0.00	0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

120 - (Chemical Conversion Coat per QSI005 4.1)

121 - (QC7-Inspect Chemical Conversion Coat)

125 - (QC5- Inspect part completeness to step on W/O)

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 5/74342 Sikaflex expire date: 12/08/2019 Start: 3:25pm Time: August 6/19 Finish: 3:25pm Time: August 7/19 ***** (Adhere for 12 hours)*****

135 - (QC5- Inspect part completeness to step on W/O)

140 - 1- Bend FWD end of tube using bender 1 and bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurment*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow out chips from inside of tube.

150 - (QC5- Inspect part completeness to step on W/O)

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod

2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4-Deburr and blow out chips from inside of tub 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

170 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

210 - (QC3- Inspect Part Finish)

240 - 1-Install wearplates as per Dwg D3887. 2 -Inspect for foreign objects as per QSI 024 3 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 4

-Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 5- INSPECT TORQUE ON BOLTS AS PER DWG.

BY: _____ DATE: _____ 6-Wing Walk as per dwg QSI005 4.4 Batch: _____

250 - (QC5- Inspect part completeness to step on W/O)

260 - (Identify as per dwg & Stock Location: _____) Location : FG108

265 - Photocopy bluefile & type labels per PPP D119-846-241 CHG005

270 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	5168371
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes - 3 - B4B	
D3885-1	Standard Web	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	516688
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B	
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-Handfinish - 4-1-Assembly-B4B	
AN3C46A	Bolt	8 Ea (8 ea)	240-Handfinish - 4-1-Assembly-B4B	
AN3C5A	Bolt	2 Ea (2 ea)	240-Handfinish - 4-1-Assembly-B4B	
D2855-3	Cap	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	
D2855-5	Cap	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	
D3492-045	Plug Assembly	8 pcs (8 ea)	240-Handfinish - 4-1-Assembly-B4B	
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-Handfinish - 4-1-Assembly-B4B	
D3849-041	Fwd Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	
D3849-043	Aft Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	
D3904-1	Washer	16 pcs (16 ea)	240-Handfinish - 4-1-Assembly-B4B	
MS21043-3	Nut	8 Ea (8 ea)	240-Handfinish - 4-1-Assembly-B4B	
MS24694-C52	Screw	2 Ea (2 ea)	240-Handfinish - 4-1-Assembly-B4B	
NAS1149C0332R	Washer (AN960C10L)	2 Ea (2 ea)	240-Handfinish - 4-1-Assembly-B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	73	0
140-Skidtubes - 3 - B4B	D2579	2	93	0
	D3885-1	1	20	0
160-Skidtubes - 4 - B4B	D3681-1	12	84	0
	D3903-1	12	79	0
240-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	1	827	0
	AN3C46A	8	222	0
	AN3C5A	2	783	0
	D2855-3	1	78	0
	D2855-5	1	41	0
	D3492-045	8	4	0
	D3672-1	2	1,587	0
	D3849-041	1	1	0
	D3849-043	1	7	0
	D3904-1	16	72	0
	MS21043-3	8	906	0
	MS24694-C52	2	60	0
	NAS1149C0332R	2	4,347	0

Part Specifications

Specifications could not be found.

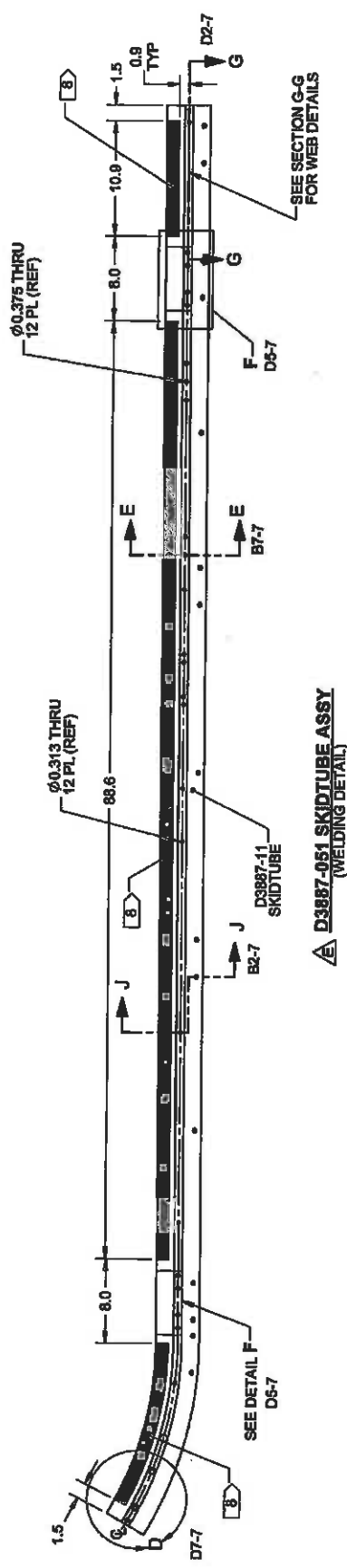


62-50-61

2017-05-08
17-512
RELEASED

DART AEROSPACE USA, INC.

ITEM	QTY	PIN	DESCRIPTION
	051		
	X	D3887-051	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3881-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-11	SKIDTUBE
5	12	D3883-1	CROSS BOLT SPACER
6	30	ALS4-1032-130	INSERT



A D3887-051 SKIDTUBE ASSY
(WELDING DETAIL)

- NOTES:
- 1) MATERIAL: NA
 - 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
 - 4) UNLESS OTHERWISE NOTED
 - 5) BREAK SHOWN: NA
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: NA
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

RELEASED
2017-05-08
APPROVED

DESIGN	RF	WK	RF	DD	HS	DATE	17.02.03
DRAWN							
CHECKED							
INFO. APPR.							
APPROVED							
DE APPR.							
DATE							

DART AEROSPACE USA, INC.
EUGENE, OR

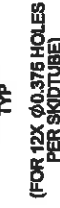
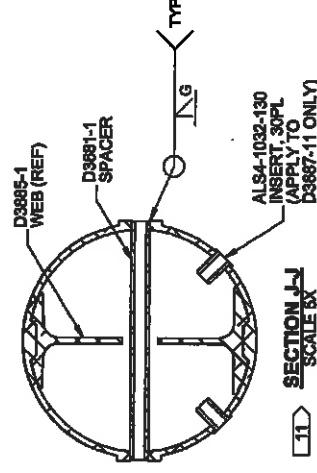
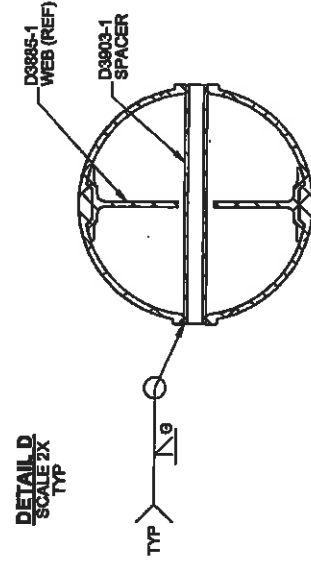
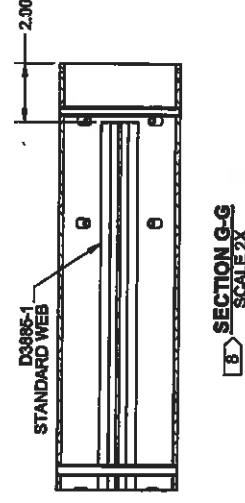
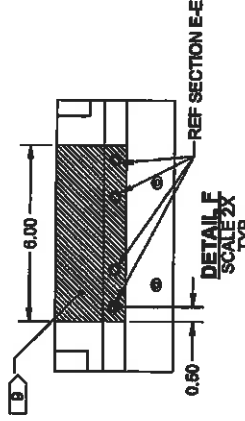
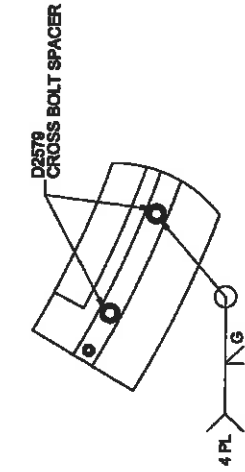
DRAWING NO.
D3887

TITLE
A119 STD SKIDTUBE ASSY

REV. E
SHEET 5 OF 11

SCALE
NTS

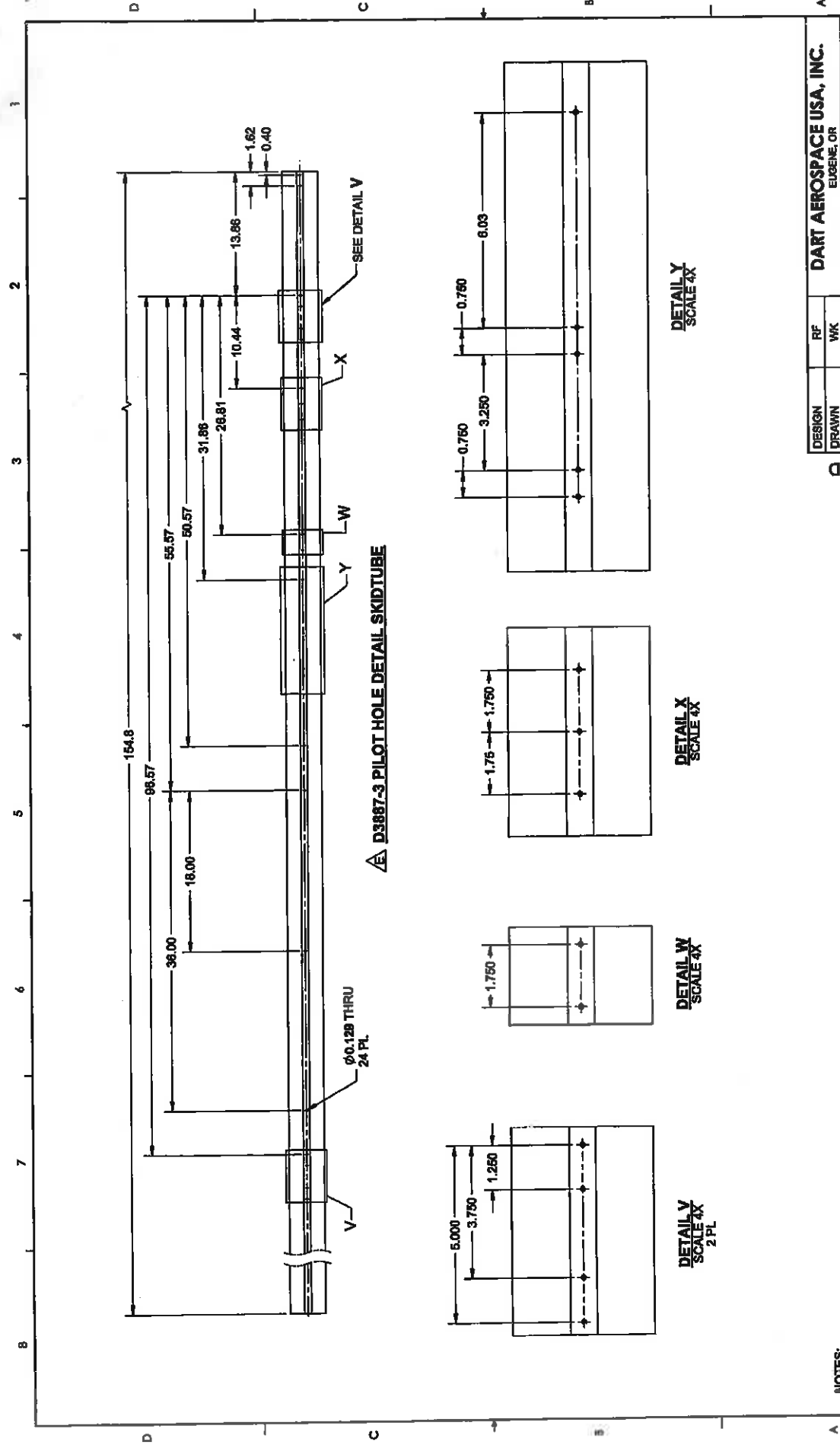
NOT TO BE USED FOR ANY PURPOSES OR CONDITIONS IN WHICH THE ORIGINAL WAS NOT USED.



- NOTES:
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAKS SHARP EDGES: 0.00R TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-1-241 TO LOCATION SHOWN OFF AFT END OF WITH SIKAFLEX-231/281 ADHESIVE PER DART QSI 016 AFTER MASK THIS AREA AND DO NOT POWDER COAT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOING:
- 10) CHAMFER HOLES 0.0170 x 48"
 - i) WELD INTO PLACE
 - ii) GRIND FLUSH
 - iii) DEBURR HOLES
 - iv) CRORE TO 0.0313 x 0.75 DEEP
- 11) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING:
 - i) CHAMFER HOLES 0.0354 x 48" OR 0.050 DEEP x 48" (80°)
 - ii) INSERT D3881-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
 - v) WELD PER DART QSI 004
- 12)

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	RF	DRAWING NO.	
MFG. APPR.	DD	D3887	
APPROVED	HS	REV. E	
DE APPR.	DS	SHEET 7 OF 11	
DATE	17.02.03	TITLE	
		A119 STD SKIDTUBE ASSY	
		SCALE	
		NTS	
		COPYRIGHT © 2003 BY DART AEROSPACE USA, INC.	
		ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	

12) WELD PER DART QSI 004



DETAIL Y
SCALE 4X

DETAIL X
SCALE 4X

DETAIL W
SCALE 4X

DETAIL V
SCALE 4X
2 PL

- NOTES:
- 1) MATERIAL: MAKE FROM D2500-1-180 EXTRUSION
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSD18 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A

RELEASED
2017-05-08

APPROVED

DESIGN	RF	WK	DRAWING NO.	REV. E
DRAWN	RF	RF	D3887	SHEET 11 OF 11
CHECKED	RF	RF	D3887	SCALE
MFG. APPR.	DD	DD	A119 STD SKIDTUBE ASSY	NTS
APPROVED	HS	HS		
DE APPR.	DS	DS		
DATE	17.02.03			

DART AEROSPACE USA, INC.
EUGENE, OR

EXTRUSION: D2500-1-180

FINISH: N/A

TOLERANCES: PER DART QSD18 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY

WEIGHT: N/A



NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Cross tube Small Fab Finishing Machining Large Fab Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					
						Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: 198190
Part No. D119-646-241

DISPOSITION

Rework ☐
Scrap ☒
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☒
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: 19-8-20 Sequence #: 140

QTY Affected: 1

MRB (QSI042)

Description Work Order Deviation

Disposition

Tube kinked During Bending

UNUSABLE, SCRAP

SAVED D3885-1 WEB

Completed By

TW
19-08-20

Lead hand / Supervisor

TW
19-08-20

QC / QA Coordinator

GB
19-08-20

AUG 29 2019

Root Cause

Operator ☒
Manufacturing Process ☒
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☒
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐